

Work Order ID 105172

July-25-13 10:42:32 AM

\*105172\*

Page 1

Item ID: D2654-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Web

Stop \*NS2\*

Start Date: 7/25/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/08/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-07-25 Tooling:

Date: 9

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date: 9

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2654	F

100		0.00
-----	--	------

\*100\*

Skidtubes  
Skidtubes  
Skidtubes

Skidtubes

Memo

0.00

1-Cut D2600-5 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Deburr holes and ends

110	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

\*110\*

QC

Quality Control

Memo

0.00

120	Chemical Conversion Coat per QSI005 4.1	0.00
-----	---	------

\*120\*

HandFinish

Hand Finishing

Memo

0.00

13-7-25 DC/DC

13-7-25 DC/DC

13-7-25 DC/DC

13-7-26

DC/DC

Work Order ID 105172

July-25-13 10:42:32 AM

\*105172\*

Page 2

Item ID: D2654-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Web

Start Date: 7/25/13

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/08/13

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

\*130\*

QC

Memo

0.00

Quality Control



DP

13-7-30

140

Identify as per dwg & Stock Location:

0.00

\*140\*

Packaging

Memo

0.00

Packaging

DL  
DP

13-7-30

(6)

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

13/7/31

13-07-30

# Picklist Print

July-25-13 10:42:36 AM

Work Order ID: 105172

Parent Item: D2654-3

Parent Item Name: Web

\*105172\*

\*D2654-3\*

Start Date: 7/25/13

Required Date: 8/08/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D 99.02.04 Fixed typo. Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	65.0000	1	6			

\*D2600-5-108\*

Extrusion 'I Beam' thin

\*\*

## Location

LG

73909

90684

## Loc Qty

65

2

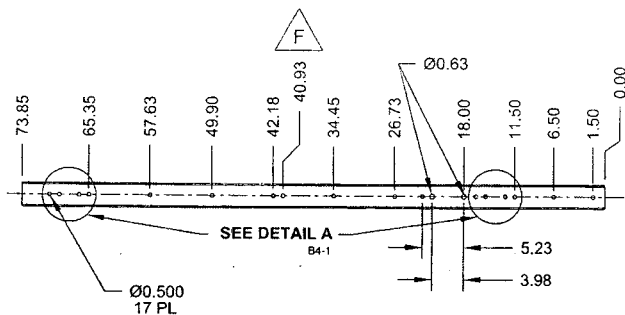
63

## Loc Code

6

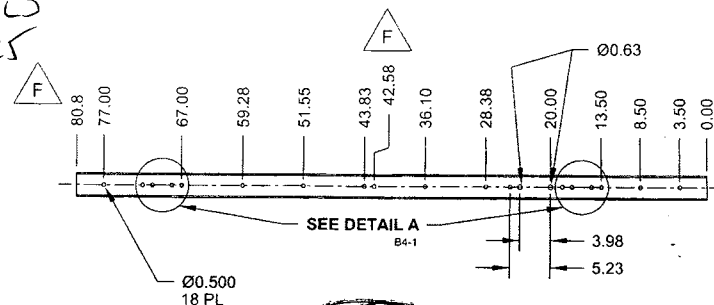
13-07-25

D/10

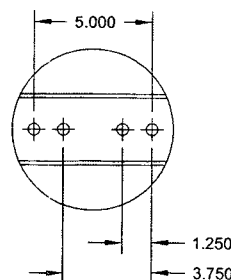


**D2654-1 WEB**

105172 MLJ  
13-07-25



**D2654-3 WEB**



**DETAIL A**

**NOTES:**

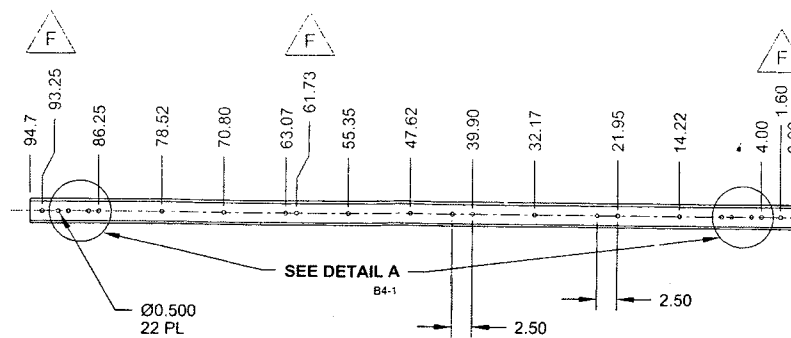
- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

RELEASED  
2011-09-12

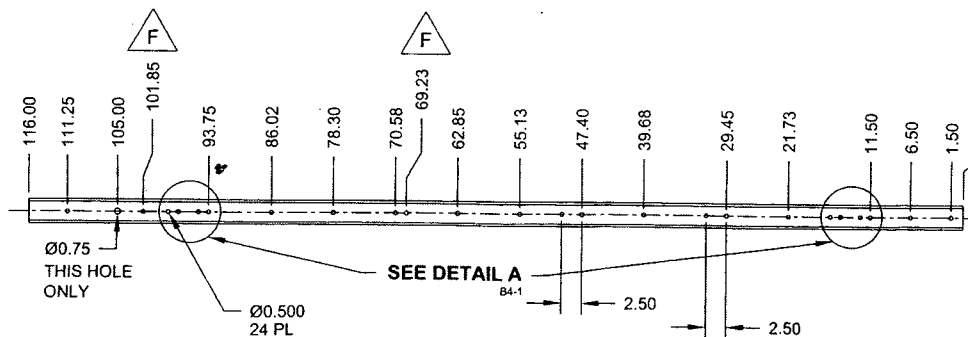
REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHV HOLES CHANGED TO Ø0.63	CP	98.01.16
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP	DRAWING NO. D2654 TITLE WEB REV. F SHEET 1 OF 2 SCALE NTS	
DATE	11.05.05		

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105172



**D2654-5 WEB**



**D2654-7 WEB**

**RELEASED**  
2011-09-12

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>JP</i>	D2654	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	